

Date: Tuesday, 23/09/2008 10:22:12 AM
 User: Julie Lecocq

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	COVER
Job Number :	42224		
Estimate Number :	10287		
P.O. Number :		Part Number :	D32021
This Issue :	23/09/2008	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D3202 REVC
First Issue :	1/1	Project Number :	N/A
Previous Run :	40853	Drawing Revision :	C
Written By :		Material :	
Checked & Approved By :	<u>JULIO 08.9.23</u>	Due Date :	20/10/2008
Comment :	Est Rev:B No Longuer Made In House 05-11-06 JLM	Qty:	50
	Est Rev:C Now on Waterjet 07-04-18 JLM	Um:	Each
	Est Rev:D chg to revC as per dwg 08-04-21 DD		
	verified by:JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M5052H32S032	5052-H32 .032 Sheet
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Comment: Qty.: 2 sf(s)/Unit Total: 81 sf(s)
 5052-H32 .032 Sheet
 Batch: 109478 B 8-10-27

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
 1-Cut as per Dwg D3202
 Dwg Rev: C B 8-10-27
 Prog Rev: C
 2-Deburr if necessary B 8-10-27



3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

S 08/10/27 counted (52)

5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1
 Chemical Conversion Coat as per QSI 005 4.1

m-h 08/10/28 (SIX)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 23/09/2008 10:22:12 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: COVER

Job Number: 42224

Part Number: D32021

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

POWDER COATING

POWDER COATING



M 106442



(SIX)

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

1:50
320 OF
2:20

M-1 08/10/31

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

P-8/11/4 (51)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

P-8/11/4 (51)

9.0

QC21

FINAL INSPECTION W/O RELEASE



08/11/05 J

Comment: FINAL INSPECTION W/O RELEASE

Job Completion



M-1 08-10-04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

D3065-5DART AEROSPACE LTD		Work Order: 42224
Description: Cover		Part Number: D3202-1
Inspection Dwg: D3202	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.38	+0.006/-0.001	.381	x			
0.63	+/-0.030	.631	x			
3.38	+/-0.030	3.38	x			
2.40	+/-0.030	2.394	x			
0.82	+/-0.030	.822	x			
73.84	+/-0.030	73.845	x			
74.50	+/-0.030	74.50	x			
0.032	+/-0.010	.031	x			
4.03 Pitch	+/-0.030	4.03	x			

Measured by: B	Audited by: S	Prototype Approval:	N/A
Date: 8-10-27	Date: 08/10/27	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.02.25	New Issue	KJ/RF	
B	06.09.28	Revised per Rev. B1	KJ/JLM	
C	08.07.23	Dimensions updated per Dwg Rev C	KJ/DD	

8

7

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5

4

3

2

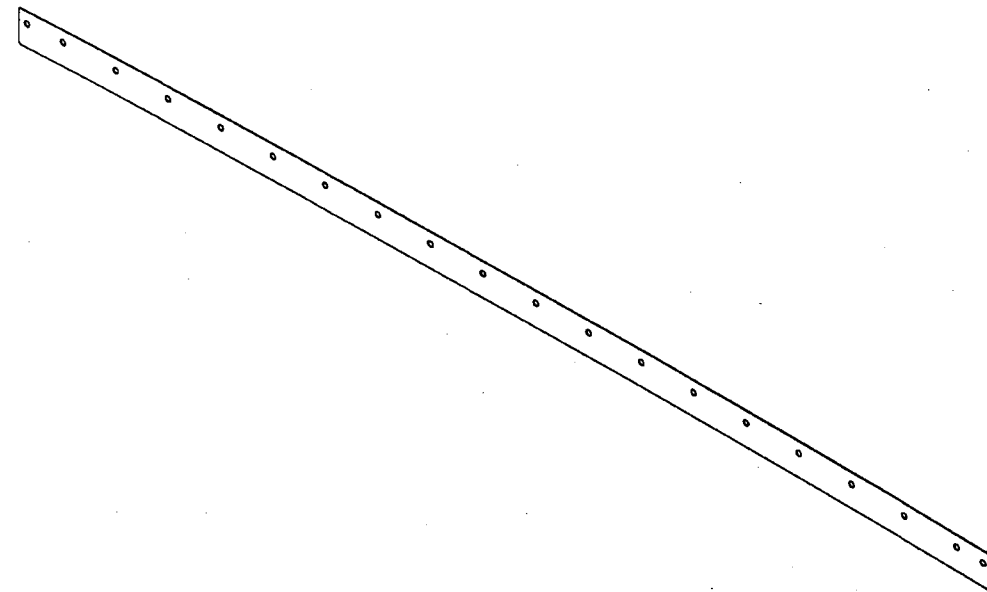
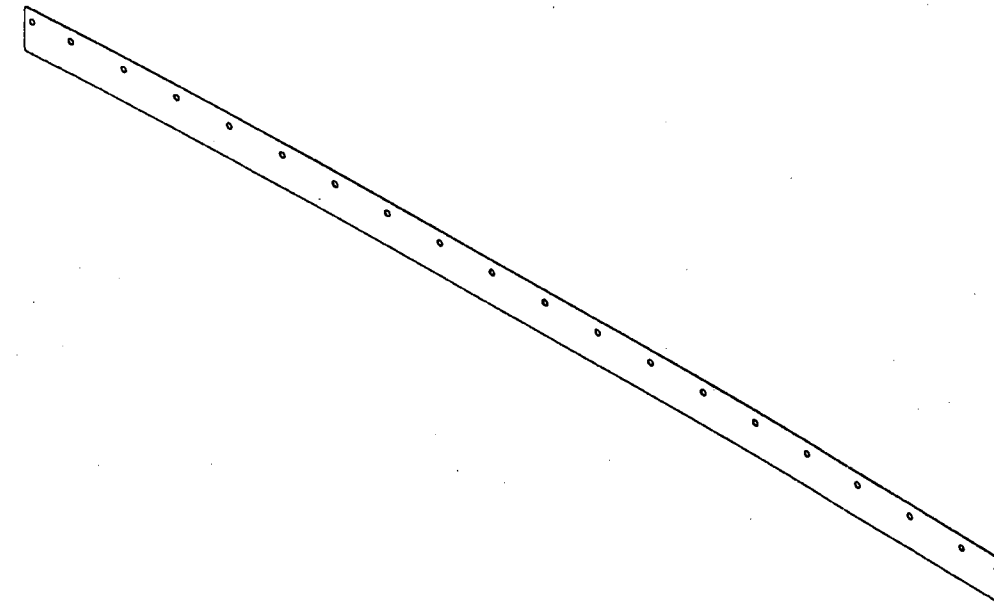
1

D

C

B

A

**D3202-1 COVER****D3202-3 COVER
(COMPOSITE DOOR)****NOTES:**

- 1) MATERIAL: 5052-H32 ALUMINUM SHEET, 0.032 THICK
PER AMS-QQ-A-250/8 OR AMS 4016
REF. DART SPEC M5052H32S.032
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3202-X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.56 lbs APPROX FOR -1
: 0.61 lbs APPROX FOR -3

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08-26-14

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C	ADD -3 FOR COMPOSITE DOOR. REFORMAT ENTIRE DRAWING TO SOLIDWORKS STANDARD. INCORPORATE CHANGE B1 (CLARIFY MID-SPAN DIMENSION)	AJS	08.03.31
B	RE-DESIGN PART NOW CURVED	CP	03.10.16
A	NEW ISSUE	CP	01.01.01
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>[Signature]</i>	D3202	SHEET 1 OF 2
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	COVER	NTS
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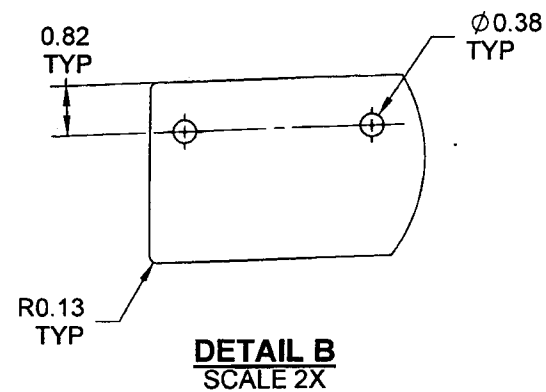
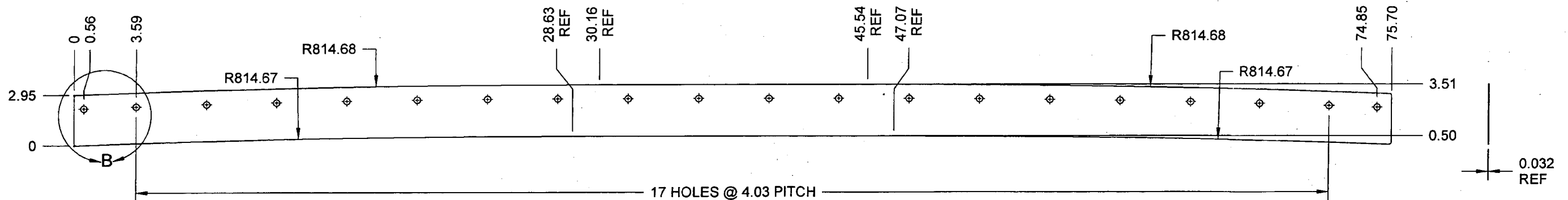
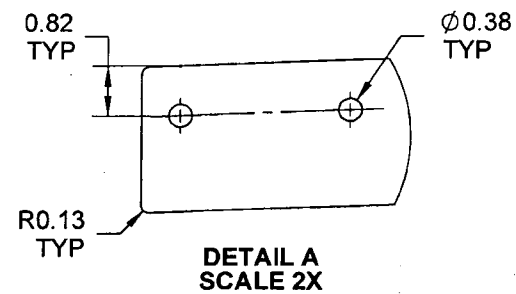
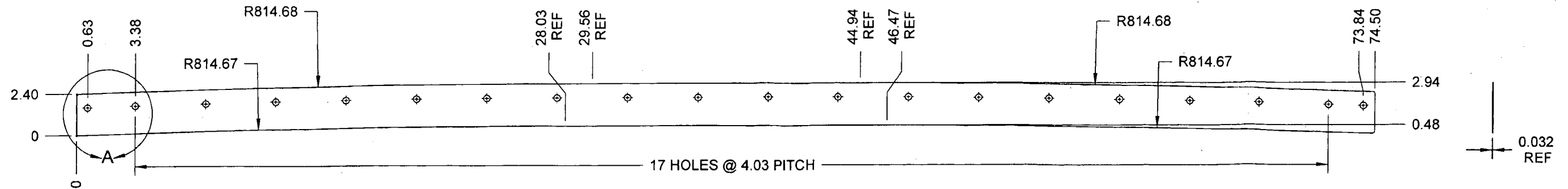
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08-06-26

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DESIGN	DS	DART AEROSPACE LTD	
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CHECKED		DRAWING NO.	REV. C
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